· • · · · · · · · · · · · · · · · · · ·	ay, 20/10/2006 2:32:00 PM a Lacelle	Process Sheet	Split posio-	7
Customer Job Number Estimate Number P.O. Number This Issue Prisht Rev. First Issue Previous Run Written By Checked & Approv	: Est Rev:A 06.10.20 New issue ec	Part Number Project Number Project Number Drawing Revision Material Due Date	: REPLACEMENT SHIM KIT : D412698021 : N/A : N/A : N/A : N/A : 11/11/2006	4 Um: E
Additional Produc	t .			
Job Number:				
Seq. #:	Machine Or Operation:	Description :		
1.0		DOCUMENT CONTROL		
				(5)
Comm	nent: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP	D412-698-021 CHG001	KJ 0610 3	₹3.
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOUR		
Comm	nent: SMALL & MEDIUM FAB RESOURCE 1		eren in de la companya de la company	
	MAKE D3238-1 (3 PER KIT) PER DRWG D3238 REV.A	6 10 20	. 03	15).
3.0		2024-T3 .080 sheet		
Comm	nent: Qty.: 0.0360 sf(s)/Unit Total : 0.1800 2024-T3 .080 sheet ///3/4/	of(s)		
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOUR	CE 1	•
Comm	nent: SMALL & MEDIUM FAB RESOURCE 1		_	2
	MAKE D3238-3 (1 PER KIT) PER DRWG D3238 REV.A	31026	(5)	<u> </u>
5.0	M2024T3S080	2024-T3 .080 sheet		
Comm	nent: Qty.: 0.0120 sf(s)/Unit Total: 0.0600 2024-T3 .080 sheet 1848/	sf(s) M B	10 25	
			**	: -

Friday, 20/10/2006 2:32:00 PM Linda Lacelle Uşer: **Process Sheet** Drawing Name: REPLACEMENT SHIM KIT Customer: CU-DAR001 Dart Helicopters Services Part Number: D412698021 Job Number: 29087 Job Number: **Description:** Seq. #: **Machine Or Operation:** SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 MAKE D3238-5 (2 PER KIT) PER DRWG D3238 REV.A M2024T3S080 7.0 0.1200 sf(s)Comment: Qty.: 0.0240 sf(s)/Unit Total: 2024-T3 .080 sheet M1848/ 8.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 MAKE D3238-11((6 PER KIT) PER DRWG D3238 REV.A M5052H32S020 5052-H32 .020 Sheet 9.0 0.3600 sf(s)Comment: Qty.: 0.0720 sf(s)/Unit Total: 5052-H32 .020 Sheet M 3019 10.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 MAKE D3238-13 (2 PER KIT) PER DRWG D 3238 REV.A 11.0 0.0240 sf(s)/Unit Total: Comment: Qty.: 5052-H32 .020 Sheet 7/30/9 12.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 MAKE D3238-15 (4 PER KIT) B1027 PER DRWG D3238 REV.A

Date: Friday, 20/10/2006 2:32:00 PM User: Linda Lacelle **Process Sheet** Drawing Name: REPLACEMENT SHIM KIT Customer: CU-DAR001 Dart Helicopters Services Job Number: 29087 Part Number: D412698021 Job Number: Description: Seq. #: **Machine Or Operation:** 5052-H32 .020 Sheet M5052H32S020 13.0 0.2400 sf(s) Comment: Qty.: 0.0480 sf(s)/Unit Total: 5052-H32 .020 Sheet 1 3()/S 14.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 15.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-698-021 3 X D3238-1 B 29 687 1 X D3238-3 B 29457 2 X D3238-5 B 290 87 6 X D3238-11)B 29017 2 X D3238-13B 2 8027 4 X D3238-(75)B_ Location: PPP Rev: 16.0 QC4 Comment: INSPECT 100% KITS FOR COMPLETENESS FINAL INSPECTION/W/O RELEASE 17.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE C.206119125 Job Completion paid della sloduie m. R. A 06 HD Ĵ

Page 3

-1 = 6+3 -13 = 7+1 -5 = 6+2 - 3 = 7+2 -15 = 7+8 -11 = 15+3



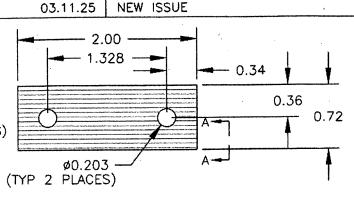


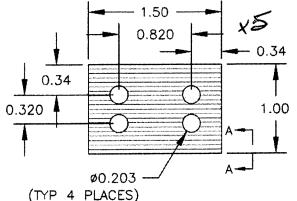
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	DESIGN	DRAWN BY	DART AERO HAWKESBURY, O	
	CHECKED	APPROVED	DRAWING NO.	REV. A
	#	-	D3238	SHEET 1 OF 1
	DATE		TITLE	SCALE
	03.11.25		PLATE	1:1
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RELEASED

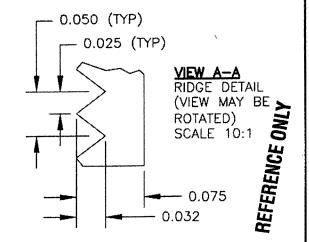
D3238-1 PLATE (SHOWN)
D3238-11 PLATE (SIMILAR)
(SAME. EXCEPT 0.020" THICK, NO SERATIONS)





D3238-3 PLATE (SHOWN)
D3238-13 PLATE (SIMILAR)
(SAME, EXCEPT 0.020" THICK, NO SERATIONS)

D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SIMILAR)
(SAME, EXCEPT 0.020" THICK, NO SERATIONS)



D3238-1/-11/-3/-13/-5/-15 PLATE

- 1) MATERIAL, -1/-3/-5: 2024-T3 SHEET (QQ-A-250/4) (REF DART SPEC M2024T3S) -11/-13/-15: 5052-H32 SHEET (QQ-A-250/8) (REF DART SPEC. M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 004 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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ite: Friday, er 'Kim Joh	10/20/2006 11:10:10 AM			· '
er Allii Joii	Pro	cess Sheet	,	
Job Number Estimate Number P.O. Number This Issue	: CU-DAR001 Dart Helicopters Services : 29087 : 12557 : : 10/20/2006 S.O. No. :	Part Number : Drawing Number :	REPLACEMENT SHIM KIT D412698021 N/A N/A	
	: NC : // Type : MACHINED PARTS : i By : Est Rev:A 06:10.20 New issue ec	Drawing Revision : Material	N/A 11/11/2006 Qty :	5 Um : Each
Additional Product				
Job Number:				
Seq. #:	Machine Or Operation:	Description :		
		JMENT CONTROL		
Commen	t: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D4;	12-698-021 CHG001		
	PACKAGING 1 PACK	AGING RESOURCE #1		
	t: PACKAGING RESOURCE #1 Pick Packing Kit	14 (35,080		
3.0 Comment	D32381 Plate t: Qty.: 3.0000 Each(s)/Unit Total: 15.0000	Each(a)		·
	Plate Batch:	l Ol	12 sx	-
4.0	D32383 Plate			
Comment	Plate Batch:	Each(s)		
	D32385 Plate			
Comment	Cty.: 2.0000 Each(s)/Unit Total : 10.0000 Plate Batch:	Each(s)		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
0610-27	14.0	Split w/O for Addy of 1 Kit		06:10:27	1K.7		1027				

Part No: _	 PAR #:	Fault Category:	NCR: Yes	No	DQA:	Date:	
			QA: N	/C CI	losed:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section E	Verification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto			
								·			

NOTE: Date & initial all entries

* Friday, 10/20/2006 11:10:10 AM Date: • * Kim Johnston ¶ser: **Process Sheet** Drawing Name: REPLACEMENT SHIM KIT Customer: CU-DAR001 Dart Helicopters Services Part Number: D412698021 Job Number: 29087 Job Number: Description: Seq. #: **Machine Or Operation:** Plate D323811 6.0 4052H324 6.0000 Each(s) Unit Total: 30.0000 Each(s) Comment: Qty.: Plate Batch Plate D323813 7.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Plate Batch: Plate D323815 8.0 Total: 20.0000 Each(s) Comment: Qty.: 4.0000 Each(s)/Unit Plate Batch INSPECT 100% KITS FOR COMPLETENESS 9.0 QC4 Comment: INSPECT 100% KITS FOR COMPLETENESS PACKAGING RESOURCE #1 10.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-698-021 Location:_ PPP Rev: FINAL INSPECTION/W/O RELEASE 11.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

Dant Ae	ospace	5 Llu							
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	_ Date: _	
							d:	Date:	
NCR:		\	WORK ORDE	ER NON-CONFORMA	NCE (NCR	(1)			
	0755	Description of NC	Description of NC Corrective Action Se		on B	Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29087
Description: Plate	4 4	Part Number:	03238-5
Inspection DwgD3238 R	ev: A		Page 1 of 1

		1	7	T	1	1
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	+1-0.030	1.75			vern	
0.70	+1-0.030	0.70	/		vern	
0.35	H-0.030	0.35	1		verN	
0.36	+1-0.030	0.36	1		Kern-	
1.030	1-0.010	1.030	./		vern	
Ø 0.203	+0.005-0.001	0.203	✓		Yern	
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Measured by:	Audited by:	Prototype Approval:
Date: 8 N 25	Date:	Date:

Rev	Date	Change	01	Revised by Approved
Α		New Issue	1/2 D412-698-021	KJ/JLM
			,	



DART AEROSPACE LTD	Work Order:	29087
		N = 2 200 2
Description: P/Ate	Part Number:	D31385
Inspection Dwg: D338 Rev: A		Page 1 of 1

,			 ;
X	First Article	X	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1,50	H-0.030	1.50	1		Vern	
0.820	+1-0.010	0.820	1		18V N	
1.00	+1-0.030	1.000	1		Yerd	
\$0.203	+0.005-0.001	0.203	1		YEV-N	
0.320	+10000	0.320	-		1	·
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Measured by: M	Audited by:	Prototype Approval:	
Date: 06 10 26	Date:	Date:	

Rev	Date	Change	0	Revised by	Approved
Α		New Issue	1/0 2412-698-021	KJ/JLM	L



DART AEROSPACE LTD		Work Order:	89087
Description: Plate	* 2 * 2 * 2 * 2 * 2 * 2 * 2 * 2 * 2 * 2	Part Number:	3238-13
Inspection Dwg: 32'38 Rev:			Page 1 of 1

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	4-0.030	0.995	1		Vern	
1.50	71-0:030	D. STOD	✓		vers	
0.320	41-0.010	0.320	✓		VEN	·
Ø0.203	+0.005-0.00	0.205	√	,	VIVN	
	-			· · · · · · · · · · · · · · · · · · ·	V X JY - XY	
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Measured by: M: M	Audited by:	Prototype Approval:	
Date: 06 10 27	Date:	Date:	

Rev Date Change Plo Durz-LG8-OZ1 KJ/JLM	
A New Issue 1/0 1412-618-02 Roystwi	



DART AEROSPACE LTD		Work Order:	29087
N H	13.3	Part Number:	3728-11
Description: PAR		Fait Number.	
Inspection Dwg: 3738 Rev	A		Page 1 of 1

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	
0.72	4-0.030	0.71	V		VerN	
2.00	+1-0.030	1.99	/		VerN	
1.328	+1-0.010	1.325			vern	·
Ø0.203	+0.005-0.001	0.208	<i>J</i>		VEN	
-				<u> </u>	1414	
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Measured by: M. M	Audited by:	Prototype Approval:	
Date: 06 10 27	Date:	Date:	

Rev	Date	Change	0	Revised by	Approved
Α		New Issue	10 DH12-698-021	KJ/JLM	



DART AEROSPACE LTD		Work Order:	29525
	*		
Description: Plate	<u> </u>	Part Number:	DE 1887
Description: 1/Ale			3238-15
Inspection Dwg: 3238 Rev: A			Page 1 of 1

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.70	+1-0.030	0.70			Vern	
1.75	41-0.030	1.75	/		VETN	
Ø0.203	+0.005-0.001		1		vern	
1.030	4-0.010	1.028	V		PEN	
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Measured by: M. M	Audited by:	Prototype Approval:
Date: 75 10 27	Date:	Date:

Rev	Date	Change	0.	Revised by	Approved
Α		New Issue	1/0 D412-698-021	KJ/JLM	lj

